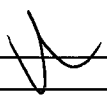


Date: Wednesday, 25/02/2009 7:31:26 AM
User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SEAT BACK (AFT FACING LH/RH)	
Job Number :	46066			
Estimate Number :	13363			
P.O. Number :		Part Number :	D37743	
This Issue :	25/02/2009	S.O. No. :		
Prsht Rev. :	NC	Drawing Number :	D3774 REV B	
First Issue :	/ /	Project Number :	N/A	
Previous Run :	41085	Drawing Revision :	B	
	Type :	Material :		
	THERMOFORMING	Due Date :	12/03/2009	Qty: 5 Um: Each
Written By :				
Checked & Approved By :				
Comment :	Est. REV:A New Issue 08.06.04 DL verified by:DD Est. REV. B Dwg. Update 08.08.19 DL			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	HAND FINISH TH	HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

Set up machine program D3774-3
Set up clamping frame as per folio

DL 09/03/04

2.0	MLEXS125F6002904	GE PLASTICS LEXAN SHEET
-----	------------------	-------------------------



Comment: Qty.: 10.6670 sf(s)/Unit Total : 53.3350 sf(s)
GE PLASTICS LEXAN SHEET
batch: *M109455*

DL 09/03/04

3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
-----	----------------	------------------------------



Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks

DL 09/03/04

(XL)

4.0	THERMOFORMING	THERMOFORMING MACHINE
-----	---------------	-----------------------



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D32811 and Folio FTA 011

Dwg. Rev. *R*
Folio Rev. *A*

BB 09/03/05 XL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 25/02/2009 7:31:27 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT BACK (AFT FACING LH/RH)

Job Number: 46066

Part Number: D37743

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BB 09/03/06 (X6)

6.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 09/03/06 (X6)

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT TRIMMED PARTS

1) Check dimensions to ensure conformity to drawing tolerances.

BB 09/03/06 (X6)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/03/06 (X6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ST256

SS 09/03/17 (X6)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/18

Job Completion



MF
09-03-17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 46066
Description: Seat Back		Part Number: D3774-3
Inspection Dwg: D3774	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 09/03/05

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3	+/-0.100	1.138	✓			
33.9	+/-0.100	34.0	✓			
17.4	+/-0.100					
0.085	Min	.100				
0.100	Min	.124				
0.100	Min	.111				
0.100	Min	.109				
0.100	Min	.107				
0.100	Min	.107				
0.100	Min	.103				
0.100	Min	.108				
0.100	Min					

Measured by: BB

Date: 09/03/05

Audited by: S

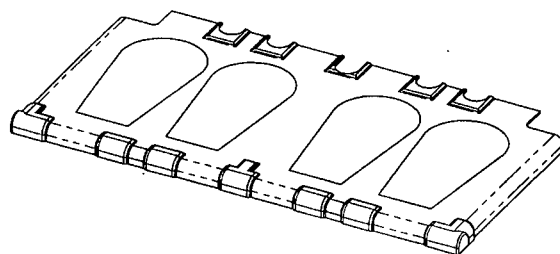
Date: 07/03/05

Prototype Approval:

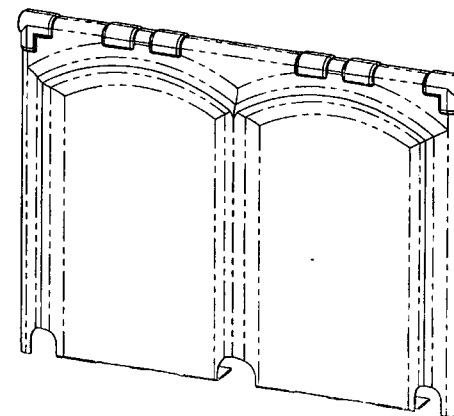
Date:

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DL	

[Handwritten signature]



D3774-1 SEAT BOTTOM



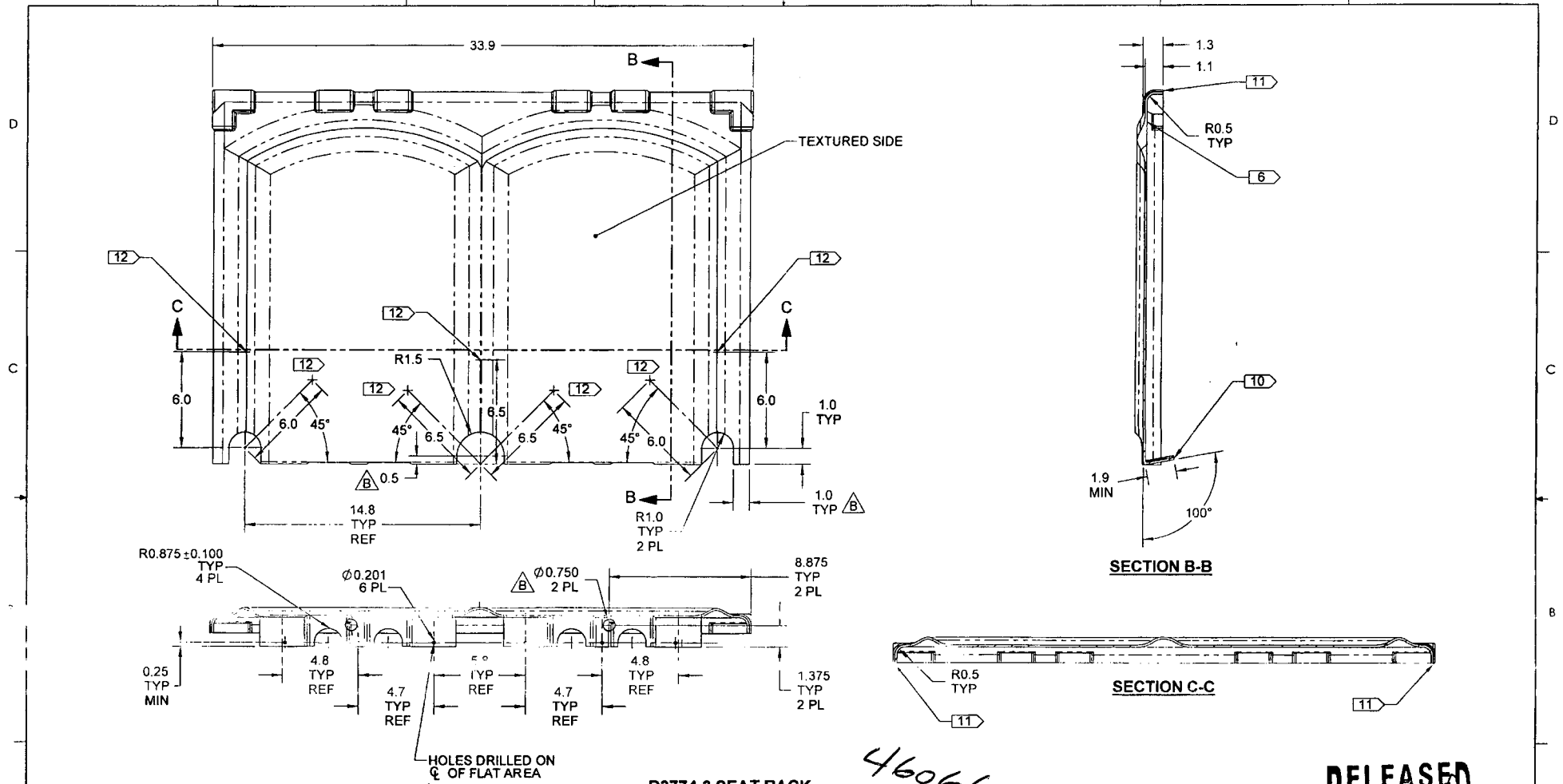
D3774-3 SEAT BACK

info

RELEASED
06-08-11/11

B	UPDATE CUTOUT DIMENSIONS (ZN D4-2, D6-2, C4-3, C7-3); UPDATE MINIMUM THICKNESS (ZN A5-2, A5-3); ADD HOLES ON D3774-3 (ZN B6-3) REASON: MANUFACTURING CAPABILITIES	PH	08.07.25
A	NEW ISSUE	HS	08.06.23
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3774 TITLE SEAT SCALE NTS	
DRAWN	PH		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH	REV. B SHEET 1 OF 3	
DATE	08.07.25	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



D3774-3 SEAT BACK

46066

RELEASED
08-07-11

- NOTES:
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125" THICK TEXTURED SIDE UP (REF. DART SPEC MLEXS.125-F60029-04)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3774-3" USING VIBRATING STYLUS
 - 7) WEIGHT: 4.82 lbs
 - 8) PART TO BE PRODUCED FROM MOLD DT9023 AND PER DART QSI 022
 - 9) OVERALL DIMENSIONS GIVEN ONLY FOR FURTHER INFORMATION REFER TO MOLD DT9023
 - 10) MINIMUM MATERIAL THICKNESS AFTER FORMING ON BOTTOM FLANGE IS 0.065
 - 11) MINIMUM MATERIAL THICKNESS AFTER FORMING FLANGES (WITHIN 2.0 FROM EDGES) IS 0.085
 - 12) MINIMUM MATERIAL THICKNESS AFTER FORMING AT THESE POINTS IS 0.100

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	RE	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3774	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SEAT	NTS
DATE	08.07.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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